

Date: Monday, 1/16/2006 4:14:50 PM
 User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	MIRROR ARM
Job Number :	25509		
Estimate Number :	10505		
P.O. Number :	N/A	Part Number :	D2010103
This Issue :	1/16/2006	S.O. No. :	N/A
Prsht Rev. :	NC	Drawing Number :	D2010 REV. C2
First Issue :	N/A	Project Number :	N/A
Previous Run :		Drawing Revision :	C2
	Type :	Material :	N/A
	SMALL / MED FAB	Due Date :	1/23/2006
Written By :	<u>SEE COMMENT Below</u>		Qty: 20 10 Um: Each
Checked & Approved By :	<u>SEE COMMENT Below</u>		
Comment :	Est: F 02.08.21 Re-format; Added D2057 KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0500W035	304 RD Tube .500 x .035W
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Comment: Qty.: 1.5750 f(s)/Unit Total: 15.7500 f(s)
 Material: 304/316 SS tubing 0.500" Dia. x 0.035" wall
 (M304TR0500W035) Batch No: M 19480

FF 06-01-26

20

2.0	BRAKE NC	NC BRAKE
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Comment: BRAKE NC
 Punch per Dwg. D2010-103-T1 and Spec Control Dwg D2727
 Identify as D2010-103

FF 06-01-26

20

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 1- Bend as per Dwg D2010 using bending Jig D2010-103T2
 2- Deburr

FF 06-01-31

20

4.0	D2057	Plug
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)
 Plug
 Pick:

Qty	Part Number	Description	Batch
1	D2057	Plug	<u>B 21675</u>

FF 06-01-31

20

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 Install D2057 plug as per Dwg D2010

FF 06-01-31

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: PA Date: 06/02/07
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/16/2006 4:14:51 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MIRROR ARM

Job Number: 25509

Part Number: D2010103

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Jdg 01/31 20

Comment: INSPECT WORK TO CURRENT STEP

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

DL 06/02/07

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *198*

DL 06/02/07

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DL 06/02/07

Job Completion



W 06-02-07

W. PK ORDF
025509

ROLL COI
F 10 MENDV

ENGINEERING

DATE 04.01.74

BY 0101

APPROVED

DESCRIPTION

CHANGE

REPORT ALL DISCREPANCIES - DO NOT SCALE

SCALE 1:1

DETAIL OF -101

DETAIL OF -103

DETAIL OF -109

DETAIL OF -111

DETAIL OF -113

DETAIL OF -109

DETAIL OF -111

DETAIL OF -113

DETAIL OF -109

DETAIL OF -111

DETAIL OF -113

DETAIL OF -109

DETAIL OF -111

DETAIL OF -113

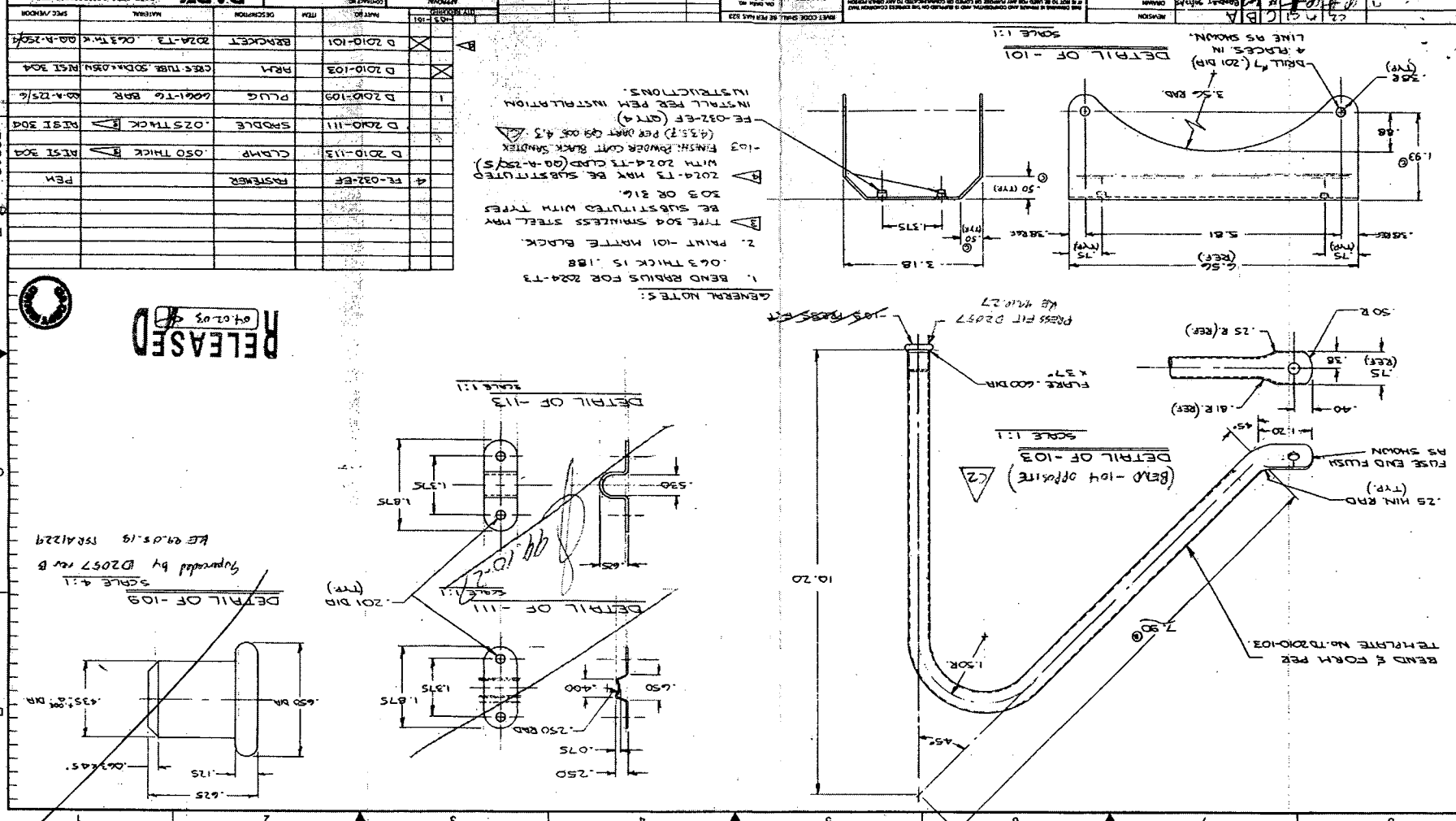
DETAIL OF -109

DETAIL OF -111

DETAIL OF -113

DETAIL OF -109

DETAIL OF -111



GENERAL NOTES:
1. BEND RADIUS FOR 2024-T3
2. PAINT -101 WHITE BLACK
3. TYPE 304 STAINLESS STEEL MAY
BE SUBSTITUTED WITH TYPES
303 OR 316
4. 2024-T3 MAY BE SUBSTITUTED
WITH 2024-T3 CLAD (20-4-15/5)
5. FINISH: POWDER COAT BLACK SANDER
(4.3.5.7) PER PART Q9 005 4.3
6. FE-032-EF (ATT 4)
INSTALL PER PER INSTALLATION
INSTRUCTIONS.

RELEASED
04.02.03

Supervised by D2057 rev B
SCALE 4:1
LE 94.05.19 15RA1229

ITEM NO.	DESCRIPTION	QTY	UNIT	REMARKS
1	2024-T3 CLAD (20-4-15/5)	1	PC	
2	2024-T3 CLAD (20-4-15/5)	1	PC	
3	2024-T3 CLAD (20-4-15/5)	1	PC	
4	2024-T3 CLAD (20-4-15/5)	1	PC	
5	2024-T3 CLAD (20-4-15/5)	1	PC	
6	2024-T3 CLAD (20-4-15/5)	1	PC	
7	2024-T3 CLAD (20-4-15/5)	1	PC	
8	2024-T3 CLAD (20-4-15/5)	1	PC	
9	2024-T3 CLAD (20-4-15/5)	1	PC	
10	2024-T3 CLAD (20-4-15/5)	1	PC	

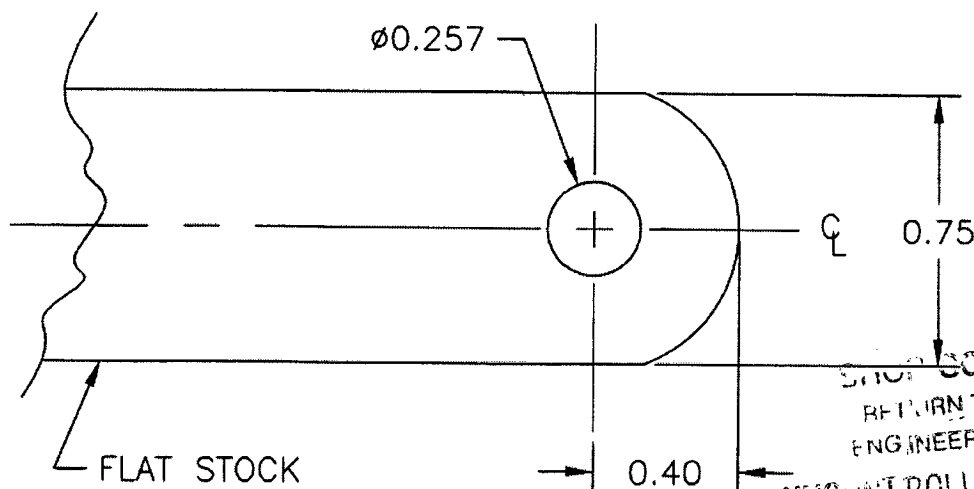
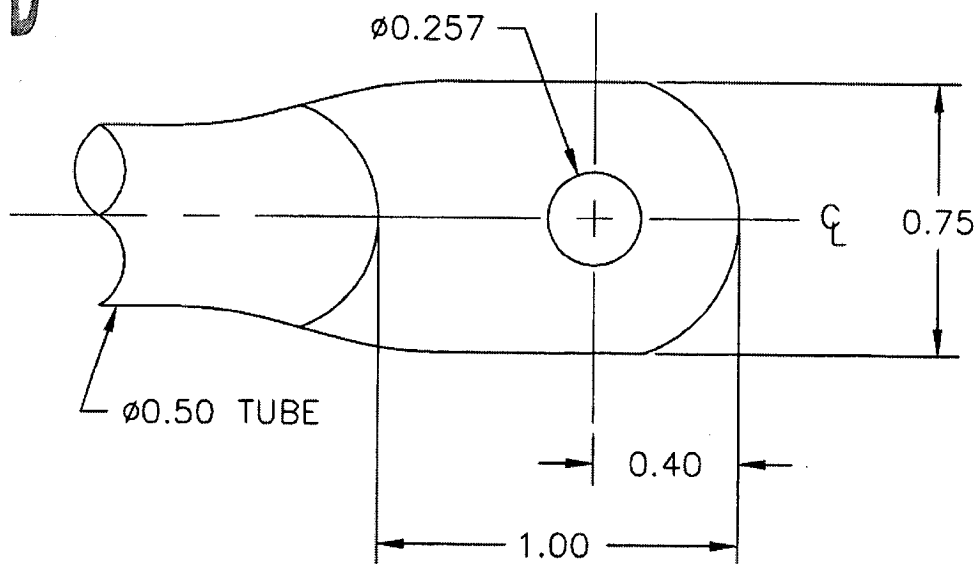
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9	2024-T3 CLAD (20-4-15/5)	1	PC	
10	2024-T3 CLAD (20-4-15/5)	1	PC	



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>my</i>	APPROVED <i>CA</i>	DRAWING NO. D2727	REV. A SHEET 1 OF 1
DATE 97.11.24		TITLE PUNCH DT8012 SPEC CONTROL	SCALE 2:1
A	97.11.24	NEW ISSUE	
A1	<i>#CP</i> 01.12.20	ADD TOLERANCE NOTE	

SPECIFICATION CONTROL DRAWING FOR PUNCH DT8012

RELEASED
98/03/06 *KE*



NOTE: TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

STOP COPY
RETURN TO
ENGINEERING
PENCNTROLLED COPY
A1